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RBE703A95-0520-01-18

Job Sheet 197412



Part No: RBE703A95-0520-01-18

Job Qty: 8 pcs *16*

DAS
21
9-89

Part Name: Quill Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/5/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A95-0520-01 Rev K IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev.B 19.02.27 drawing revision DP Verify DD/IPP Rev. C 19.05.23 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	8 pcs	9/2/19		0.00	1.60	Small Fab - 1		<i>MLL</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	8 pcs	9/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	8 pcs	9/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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Container No: S198092



Part: RBE703A95 - 0520 - 01 - 18

Job No: 197412

Serial No/Batch: S198092

Revision: K

Inspector:

Exp Date:

Instructions:

Date: 07/15/19

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130	QC 21 - SA	8 pcs	9/2/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

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Part Op **100** - Assemble as per DWG. See note 8 and 9.
 Descriptions: **110** - QC5- Inspect part completeness to step on W/O
120 - Identify as per dwg & Stock Location: _____
130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
9263K519	O-ring	8 Ea (1 ea)	100-Small Fab - 1	5161584
93600A252	316 SS Dowel Pin 2.5 mm Dia. x 6 mm Lg.	24 Ea (3 ea)	100-Small Fab - 1	12x5175976 36x5159 976
RBE703A95-0520-01-1	Quill	8 pcs (1 ea)	100-Small Fab - 1	5183156

Job Allocations

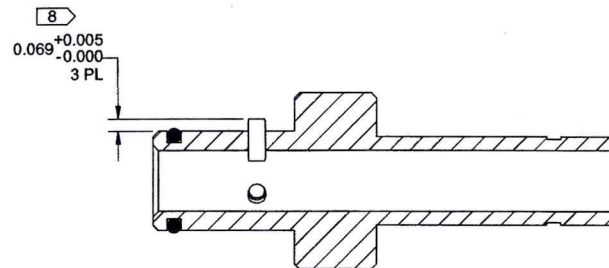
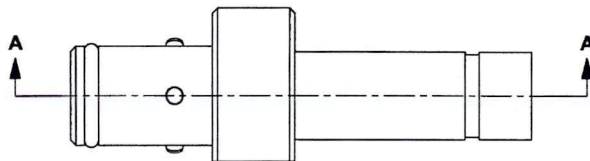
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	9263K519	8	40	0
	93600A252	24	51	0
	RBE703A95-0520-01-1	8	52	0

Part Specifications

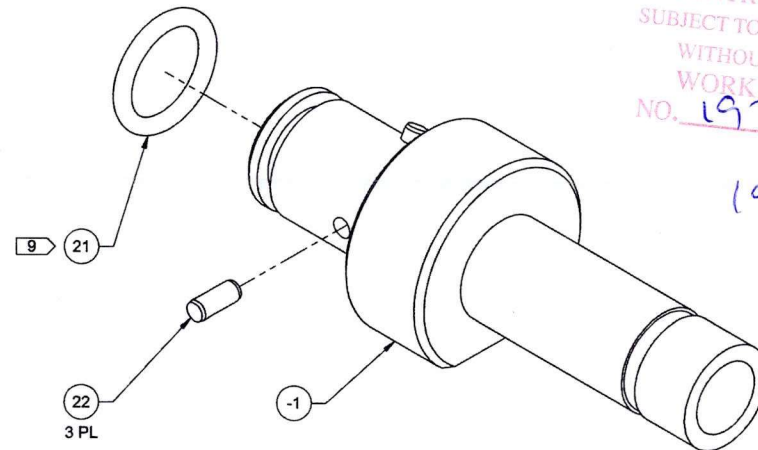
Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-1	1	RBE703A95-0520-01-1	QUILL
21	1	McMaster#9263K519 OR EQUIV.	VITON O-RING 11 mm ID. X 15 mm OD. X 2 mm THK.
22	3	McMaster#93600A252 OR EQUIV.	316 SS DOWEL PIN 2.5 mm DIA. X 6 mm LG.



SECTION A-A



RBE703A95-0520-01-18 QUILL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1^\circ$ / $\pm 1^\circ$
X.XX = $\pm 0.01^\circ$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005^\circ$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005^\circ$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005^\circ$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 22 WITH ITEM -1, AND REMOVE EXCESS
- 9) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 21 THEN ASSEMBLE WITH ITEM -1 AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. K
MFG. APPR.	DP	RBE703A95-0520-01	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		ENGINE & HYDRAULIC DRAIN TUBE	NTS
DATE	4/24/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197412
MLJ
19-07-08

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					